



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D3589-23
Job Sheet 204724



Part No: D3589-23

Job Qty: 24 pcs

Part Name: Arm Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/18/19

Job Tracking No:

Due Date: 2/27/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEET 4 IPP REV:A 12.07.23 NEW ISSUE DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		AS	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time		
100	Hardinge - 1	24 pcs	2/27/20	2/27/20	0.50	3.59	Hardinge - 1		66	20/02/22
120	QC 8	24 pcs	2/27/20	2/27/20	0.00	0.00	QC 8 - 12		9.89	
							QC 8 - 14			
							QC 8 - 17			
							QC 8 - 20			
							QC 8 - 25			
							QC 8 - 3			
							QC 8 - 32			
							QC 8 - 33			
							QC 8 - 35			
							QC 8 - 39			
							QC 8 - 4			
							QC 8 - 44			
							QC 8 - 45			
							QC 8 - 49			
							QC 8 - 58			
							QC 8 - 8			
							QC 8 - 9			
							QC 8 - 68			
							QC 8 - 67			
							QC 8 - 1 (A)			
							QC 8 - 47			
							QC 8 - 40			
							QC 8 - 52			
							QC 8 - 23			
							QC 8 - 57			53L 20/02/25
							QC 8 - 76			
							QC 8 - 61			
130	Packaging 3-1 - Stock - B4B	24 pcs	2/27/20	2/27/20	0.00	0.00	Packaging 3 - 1 - B4B			
							Packaging 3 - 2 - B4B			
							Packaging 3 - 3 - B4B			

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 02/22/20

Part: D3589 - 23
Job No: 204724
Serial No/Batch: S257652



Container No: S257652



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Plex 12/18/19 11:25 AM Dart.lajeunesse.marie

					Packaging 3 - 4 - B4B	WA 001-7	DAS 74	FEB 25 2020
					Packaging 3 - 5 - B4B		9-89	
					Packaging 3 - 6 - B4B			
					Packaging 3 - 7 - B4B			
					Packaging 3 - 8 - B4B			
					Packaging 3 - 9 - B4B			
					Packaging 3 - 10 - B4B			
					Packaging 3 - 11 - B4B			
					Packaging 3 - 12 - B4B			
					Packaging 3 - 13 - B4B			
					Packaging 3 - 14 - B4B			
					Packaging 3 - 15 - B4B			
					Packaging 3 - 16 - B4B			
					Packaging 3 - 17 - B4B			
					Packaging 3 - 18 - B4B			
					Packaging 3 - 19 - B4B			
					Packaging 3 - 20 - B4B			
					Packaging 3 - 21 - B4B			
					Packaging 3 - 22 - B4B			
					Packaging 3 - 23 - B4B			
					Packaging 3 - 24 - B4B			
					Packaging 3 - 25 - B4B			
					Packaging 3 - 26 - B4B			
					Packaging 3 - 27 - B4B			
					Packaging 3 - 28 - B4B			
					Packaging 3 - 29 - B4B			
					Packaging 3 - 30 - B4B			
					Packaging 3 - 31 - B4B			
					Packaging 3 - 32 - B4B			
					Packaging 3 - 33 - B4B			
					Packaging 3 - 34 - B4B			
					Packaging 3 - 35 - B4B			
					Packaging 3 - 36 - B4B			
					Packaging 3 - 37 - B4B			
140 QC 21 - SA	24 pcs	2/27/20	0.00 0.00		QC 21 - SA - 21		DAS 21	FEB 25 2020
					QC 21 - SA - 70		9-89	
					QC 21 - SA - 53			

Part Op 100 - (Hardinge)

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

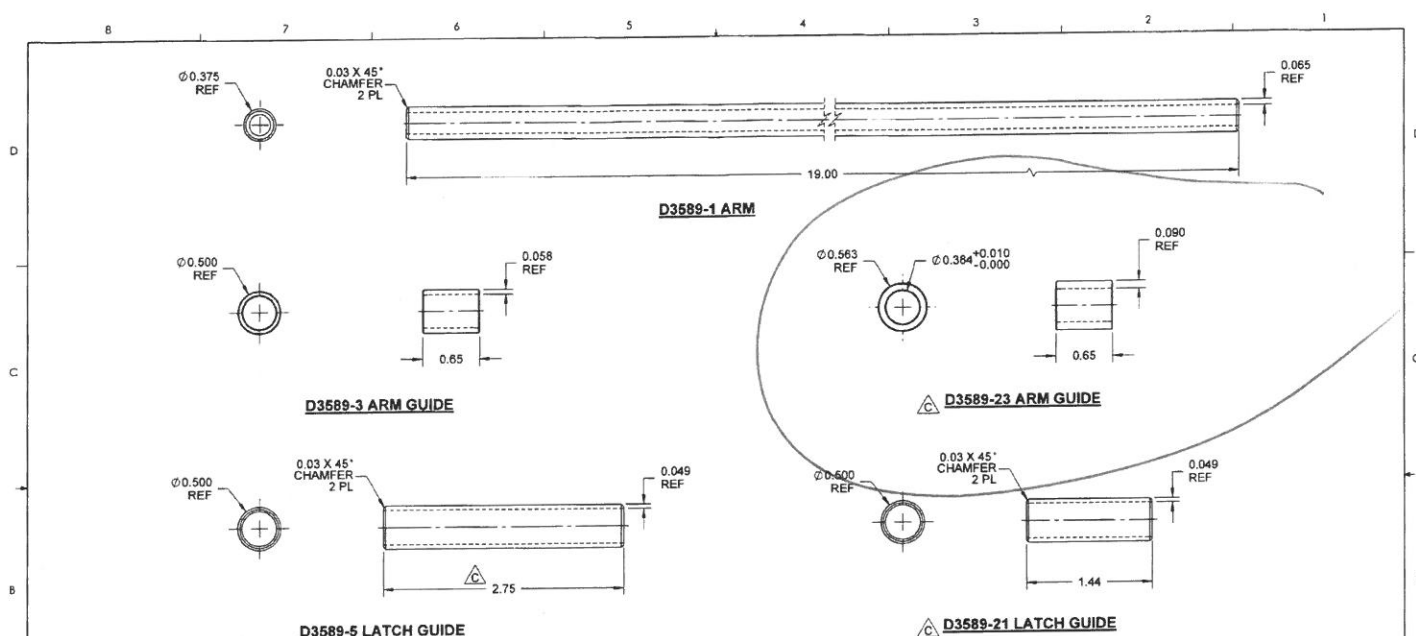
Part / Item	Component Name	Quantity	Operation	Container
M304R0.750	304 SS Roundbar .750	1.3008 ft (.0542 ea)	100-Hardinge - 1	S200820

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M304R0.750	1	28	0

Job: _____ Part No. _____		DISPOSITION <div> <div>Rework</div> <div>Scrap</div> <div>Use-as-is</div> </div>		DEPARTMENT/PROCESS <div> <div>Skid-tube</div> <div>Machining</div> <div>Large Fab</div> </div> <div> <div>Cross tube</div> <div>Small Fab</div> <div>Finishing</div> </div> <div> <div>Eng. (Non-AW)</div> <div>Prod. Eng. Coord.</div> <div>Rec/Store/Packaging</div> </div> <div> <div>Engineering</div> <div>Water Jet</div> <div>Supplier</div> <div>Quality</div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)			
Description Work Order Deviation		Disposition					
		Completed By					
		Lead hand / Supervisor					
		QC / QA Coordinator					

Root Cause <div> <div>Operator</div> <div>Manufacturing Process</div> <div>Equip/Tooling</div> <div>Handling/Preservation</div> <div>Material</div> <div>Product Improvement</div> <div>Process Improvement</div> <div>Human Factors</div> </div>		FAULT CATEGORY <div> <div>Pressure/Forced</div> <div>Bending</div> <div>Crushing</div> <div>Cracks</div> <div>Crimp/Kink/Ripple/Wave/Twist</div> <div>Marks/Chatter</div> <div>Mislabeled</div> </div> <div> <div>Contamination</div> <div>Misaligned/off center</div> <div>BOM/Route</div> <div>Broken/Damage/Defect</div> <div>Incomplete/Unclear Instructions</div> <div>Drill Holes</div> <div>Fit/Function</div> </div> <div> <div>Power Loss/Surge</div> <div>Folio/Program</div> <div>Grain Direction</div> <div>Weld</div> <div>Wrong Stock Pulled</div> <div>Out of Sequence</div> <div>Off-set/Set-up</div> </div> <div> <div>Positioned Wrong</div> <div>Outside Tolerance</div> <div>Drawing</div> <div>Finish</div> <div>Part Lost/Missing</div> <div>Misread</div> </div>									
		Other/Details:									



RELEASE
 2012-07-16

- D3589-1/-3/-5/-21-23 NOTES**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
 D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
 D3589-5/-21: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
 D3589-23: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276 (REF. DART SPEC M304R)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: - D3589-1 = 0.34 lbs
 - D3589-3 = 0.01 lbs
 - D3589-5 = 0.06 lbs
 - D3589-21 = 0.03 lbs
 - D3589-23 = 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3589	REV. C
MFG. APPR.			SHEET 4 OF 8
APPROVED		TITLE LATCH ASSEMBLY	SCALE NTS
DE APPR.			
DATE	12.07.04		